

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025654**Date Inspected:** 19-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Li Ping

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections (MT) of segment 13 West welds as part of a special inspection program, reference NWIT number 9743. This QA Inspector observed ABF Inspectors had completed and accepted MT inspections of welds: SEG3013D-195, SEG3013B-353 and SEG3013D-151. This QA Inspector performed random visual and magnetic particle inspection of welds: SEG3013D-195, SEG3013B-353, SEG3013D-151 and these welds appear to comply with AWS D1.5 MT and visual requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

This QA Inspector observed ZPMC welder Mr. Yu Hui Ye, stencil 045143 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 13CW weld SEG3015U-036. This QA Inspector observed that Mr. Yu Hui Ye appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wei Hengbin, stencil 068924 used shielded metal arc welding

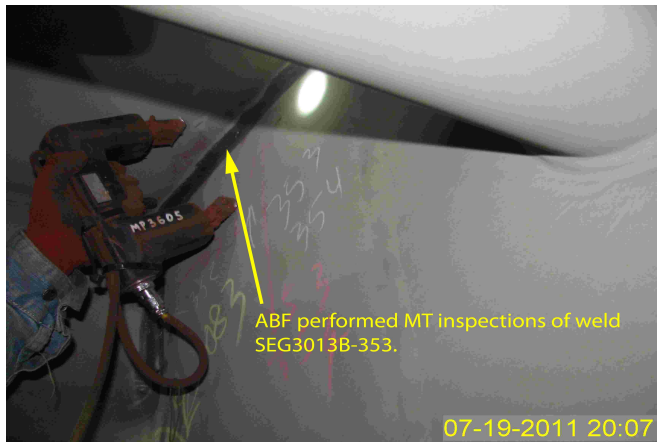
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procedure specification WPS-B-P-2212 to perform OBG segment 13BW weld SEG3014H-148. This QA Inspector observed that Wei Hengbin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Li Fayong, stencil 216872 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 13AE welds SEG3007V-273 and 274. This QA Inspector observed that Mr. Li Fayong appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Si Gao Feng, stencil 204342 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 13AE welds SEG3007V-225 and 226. This QA Inspector observed that Mr. Si Gao Feng appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
